

Date: Thursday, 13/11/2008 8:20:46 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	: 43408			Part Number	: D35645		
Estimate Number	: 12786			Drawing Number	: D3564 REVD		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 28/11/2008		
Previous Run	: 42236			Qty:	12	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC Est Rev D added.DT# 08.04.21 DD Verified by EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063 
		Comment: Qty.: 1.5750 sf(s)/Unit Total : 18.9000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 109057 HB 8-11-19
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: P HB 8-11-19 Prog Rev: D 
		2-Deburr if necessary HB 8-11-19
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		 HB 8-11-19
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 
		 S 08 u 120 (12)
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE 
		 HB 08 11 20
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 8:20:46 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43408

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT8157

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

SB 08/11/28

12

7.0 POWDER COATING

POWDER COATING



M 109 648

12x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7 = 30

OVEN TEMPERATURE:

320°

FINISH TIME:

8 = 00

m/l

08/12/01

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/12/01 12x

9.0 PACKAGING 1

PACKAGING RESOURCE #1



12x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FP - 19

m/l 08/12/01

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/02  
KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MFR 08/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

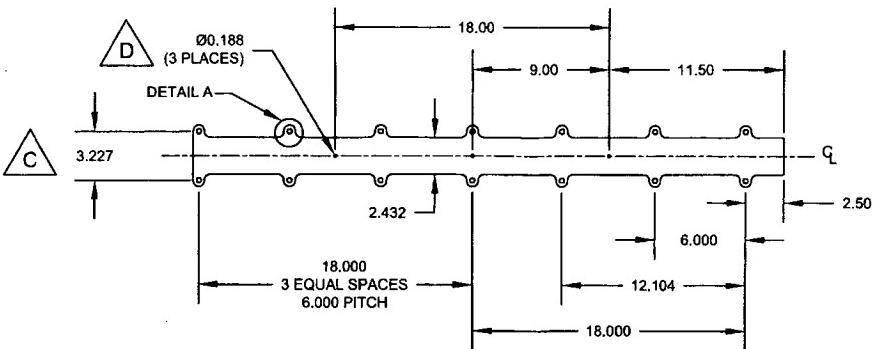
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

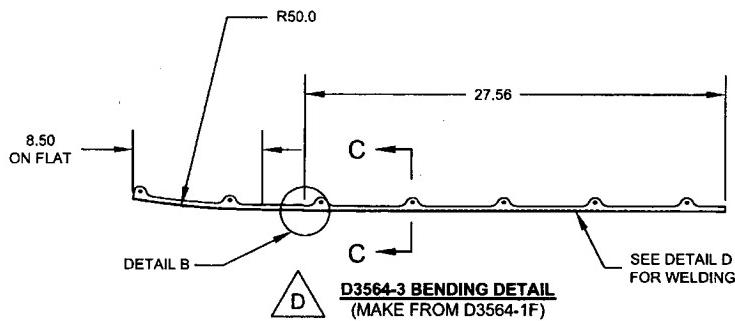
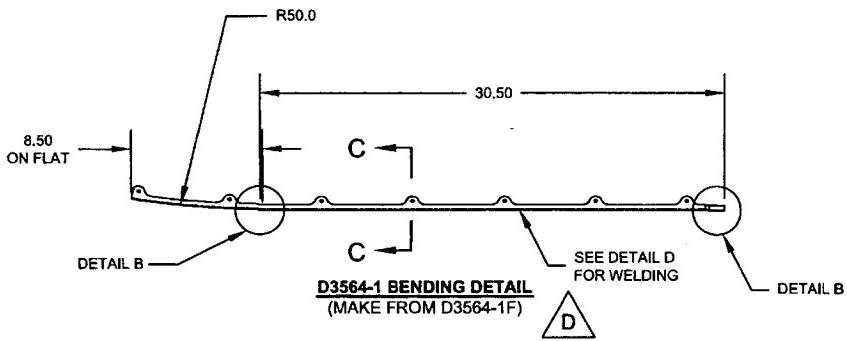
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED

07.09.04

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

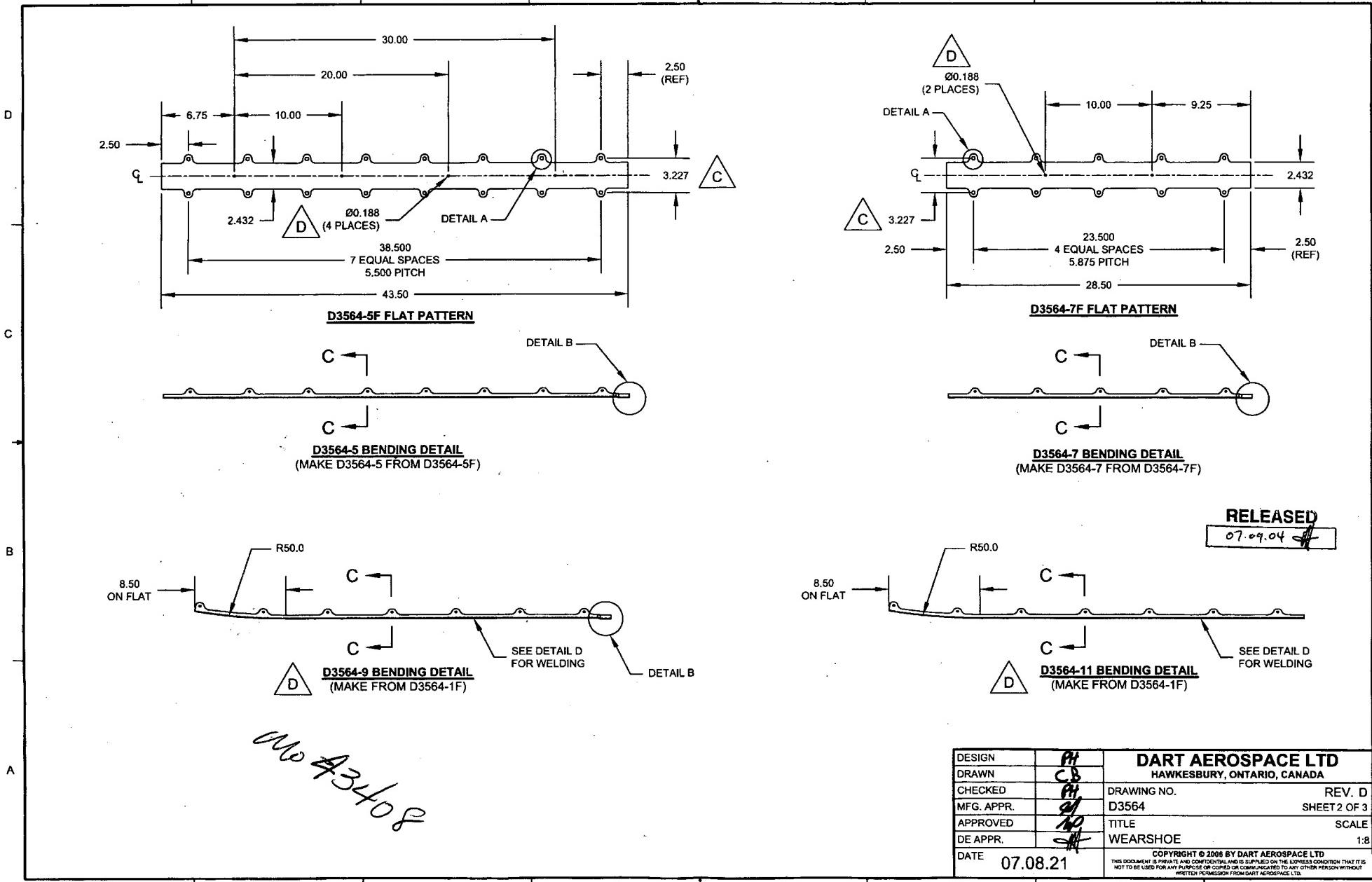
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\frac{1}{4}$

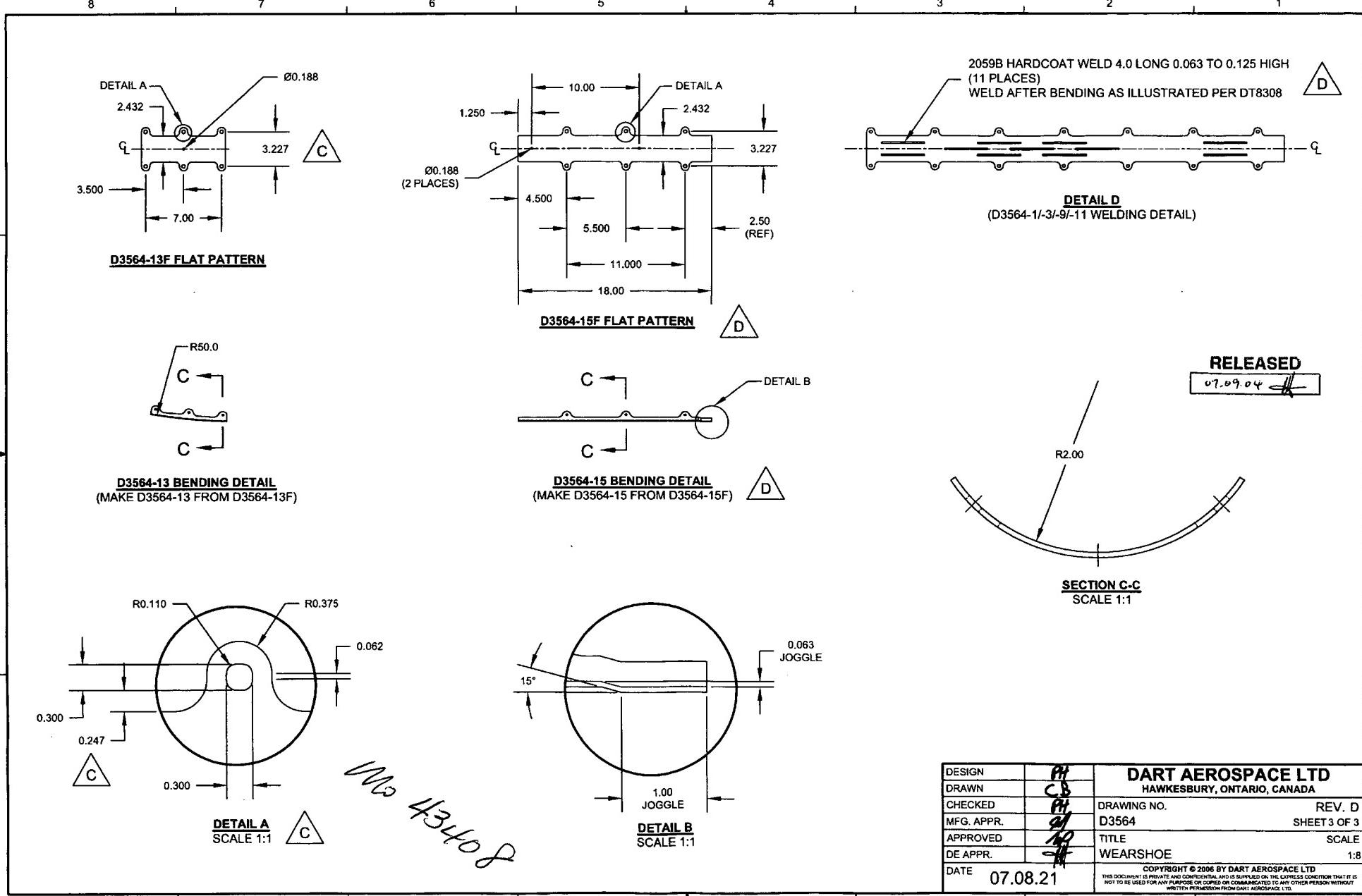
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5.7,B2: RELOCATE DETAILS AND SECTION; PG3 A5.7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>PH</i>	D3564	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE AND CONFIDENTIAL INFORMATION OF THE DART CORPORATION THAT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1





DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. D
MFG. APPR.	SI	DRAWING NO.
APPROVED	SI	D3564
DE APPR.	SI	SHEET 3 OF 3
DATE	07.08.21	SCALE
		1:8

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**DART AEROSPACE LTD**

**Work Order:** 43406

Description: WEAR SHOE

**Part Number:** D3564-5

Inspection Dwg: D3564-5 Rev: D

Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## **x First Article      x Prototype**

**Measured by:**

12

**Audited by:**

## **Prototype Approval:**

1

Date:

8-11-A

Date: 08/14/20

Date: / / A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	